



Dart Aerospace Ltd.
1270 Aberdeen St
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D4151-5
Job Sheet 195039



Part No: D4151-5

Job Qty: 24 pcs

Part Name: Fwd Basket Instl Stud



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/13/19

Job Tracking No:

Due Date: 6/20/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C SHEET 3 IPP REV:A NEW ISSUE 10-07-22 JLM VERIFIED BY:DD IPP Rev:B 11.01.21 as per dwg revC DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Doosan - 1	24 pcs	6/20/19	6/20/19	0.00	7.69	Doosan - 1		
130	QC 8	24 pcs	6/20/19	6/20/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
140	Packaging 3-1 - Stock - B4B	24 pcs	6/20/19	6/20/19	0.00	0.00	Packaging 3 - 1 - B4B		VAB 19/6/6
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		



Container No: S188134



Part: D4151-5

Job No: 195039

Serial No/Batch: S188134

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 06/06/19

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				Packaging 3 - 6 - B4B	DAS
				Packaging 3 - 7 - B4B	28
				Packaging 3 - 8 - B4B	9-89
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
150 QC 21 - SA	24 pcs	6/20/19	0.00 0.00	QC 21 - SA - 21	21
				QC 21 - SA - 70	9-89
				QC 21 - SA - 53	JUN 06 2019
Part Op 110 - (Doosan Lathe)1-Mill as per folio FA953 & dwg , Descriptions: 130 - (QC8- Inspect parts - second check) 140 - (Identify as per dwg & Stock Location: _____) 150 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M303R1.000	303 Round Bar 1.00	6 ft (.25 ea)	110-Doosan - 1	5178000	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-Doosan - 1	M303R1.000	6	69	0	

SCRAP, 095

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fwd Basket Inst. Stud (Lower)	1.000Inches ± 0.030	1.030 0.970	<i>✓</i>	Diameter
2	Fwd Basket Inst. Stud (Lower)	0.800Inches $+ 0.000$ $- 0.010$	0.800 0.790	<i>.792</i>	
3	Fwd Basket Inst. Stud (Lower)	0.750Inches $+ 0.030$ $- 0.000$	0.780 0.750	<i>.757</i>	
4	Fwd Basket Inst. Stud (Lower)	0.375Inches ± 0.010	0.385 0.365	<i>.375</i>	
5	Fwd Basket Inst. Stud (Lower)	0.500Inches ± 0.030	0.530 0.470	<i>.494</i>	
6	Fwd Basket Inst. Stud (Lower)	1.000Inches $+ 0.003$ $- 0.000$	1.003 1.000	<i>1.002</i>	
7	Fwd Basket Inst. Stud (Lower)	2.000Inches ± 0.030	2.030 1.970	<i>1.996</i>	
8	Fwd Basket Inst. Stud (Lower)	2.880Inches ± 0.030	2.910 2.850	<i>2.876</i>	
9	Fwd Basket Inst. Stud (Lower)	0.250Inches ± 0.010	0.260 0.240	<i>.241</i>	
10	Fwd Basket Inst. Stud (Lower)	0.438Inches $+ 0.000$ $- 0.010$	0.438 0.428	<i>.434</i>	Diameter
11	Fwd Basket Inst. Stud (Lower)	0.130Inches ± 0.030	0.160 0.100	<i>.120</i>	
12	Fwd Basket Inst. Stud (Lower)	0.060Inches ± 0.030	0.090 0.030	<i>1/16</i>	Radius
13	Fwd Basket Inst. Stud (Lower)	0.250Inches $+ 0.003$ $- 0.000$	0.253 0.250	<i>.252</i>	Diameter
14	Fwd Basket Inst. Stud (Lower)	0.130Inches ± 0.030	0.160 0.100	<i>1/8</i>	Radius

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					